

Work Order ID 57118

March 23, 2010 8:23:29 AM



Page 1

Item ID: D3909-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Fwd Crosstube

Start Date: 23/03/2010 Start Qty: 16.00



Required Date: 25/03/2010 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

10.03.23

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3909

Prog Rev: A

Dwg Rev: A

364 . 125

Deburr as required

10-3-23



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-3-23

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Start Date: 23/03/2010 Start Qty: 16.00



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Required Date: 25/03/2010 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 0603/26

(H6)

Pto →

150

Identify as per dwg & Stock Location: 098

0.00



Packaging

Memo

0.00

Packaging

PAK/3/SS (16)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/01

BT 10-3-29

(14)

Dart Aerospace Ltd

W/O: 57118		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/3/26	#120	took Qty +1 For QC inspection + envelope (Part has a small defect at Top Right hand corner)	S	10/09/26	+1		S 10/03/26

Part No: D3909-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 23, 2010 8:23:28 AM

Page 1

Work Order ID: 57118

Parent Item: D3909-1

Parent Item Name: Lug Plate, Fwd Crosstube

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC IPP RevB: as per revPA3
DD verified by:EC

Start Date: 23/03/2010

Required Date: 25/03/2010

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	55.5036	3.2842			



304/316 0.125 Sheet



1810-3-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	55.5036	
112663	55.5036	

16

112663

DART AEROSPACE LTD		Work Order: S7118
Description: Lug PLATE FWD CROSS TUBE		Part Number: D3909-1
Inspection Dwg: D3909-1 Rev: A		Page 1 of 1

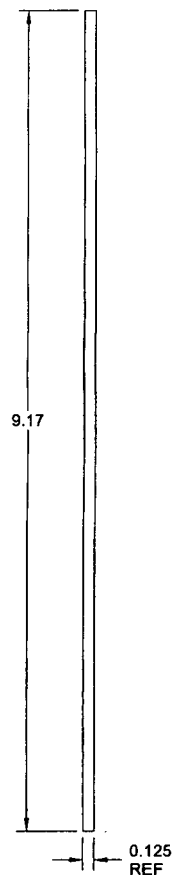
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

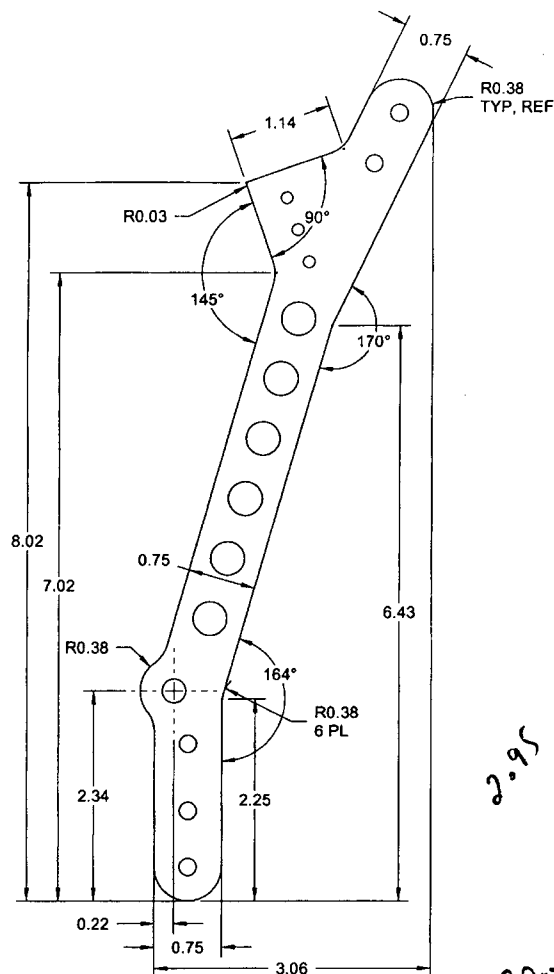
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.132	✓			
Ø .191	+ .005 - .001	.194	✗			
Ø .38	+ .006 - .001	.380	✗			
Ø .266	+ .006 - .001	.268	✗			
.38	± .030	.380	✓			
.625	± .010	.625	✓			
.38	± .030	.380	✓			
.750	± .010	.754	✓			
.375	± .010	.376	✗			
3.50	± .030	3.503	✗			
.70	± .030	.702	✓			
3.14	± .030	3.143	✗			
2.34	± .030	2.339	✓			
.610	± .010	.611	✗			
.22	± .030	.220	✓			
.38	± .030	.371	✗			
.625	± .010	.628	✗			
1.75	± .030	1.747	✗			
7.141	± .010	7.145	✓			
.75	± .030	.764	✗			
9.17	± .030	9.18	✗			
3.06	± .030	3.06	✗			
8.02	± .030	8.008	✓			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-3-23	Date: 10/03/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



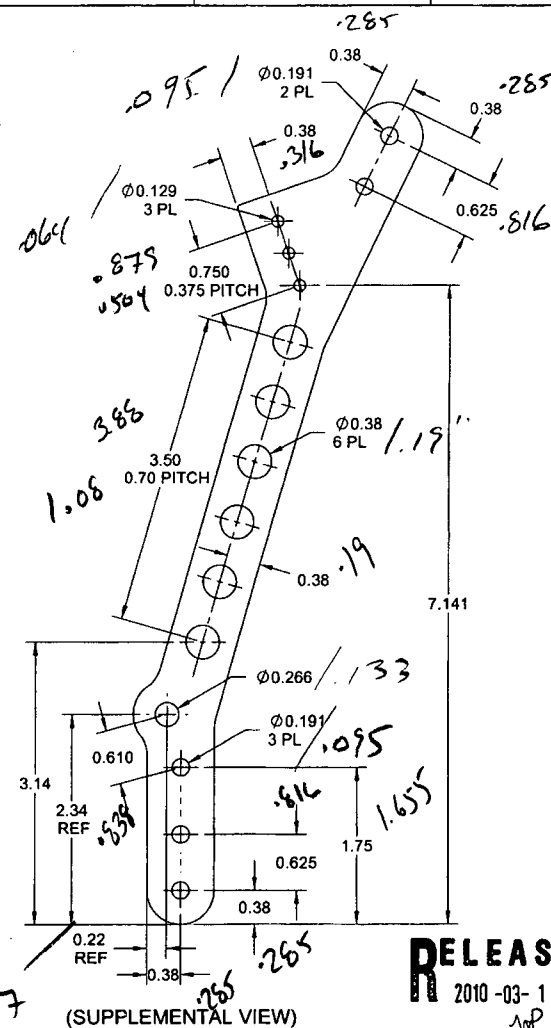
w/o 57118



D3909-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs



(SUPPLEMENTAL VIEW)

RELEASED
2010-03-12
MP

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3909	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE FWD X-TUBE LUG ASSY	SCALE
DE APPR.	<i>[Signature]</i>	NTS	
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	